

Date: Monday, 6/12/2006 2:35:12 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER
 Job Number : 27526
 Estimate Number : 10383
 P.O. Number : N/A Part Number : D30661
 This Issue : 6/12/2006 S.O. No. : N/A Drawing Number : D3066 REV. A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 27444 Material : N/A
 Written By : *SEA* Due Date : 6/19/2006 Qty: 50 Um: Each
 Checked & Approved By : *SEA* 06.06.12
 Comment : Est:C 0217.01 Incorporated D3066-1 IPP KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.0992 sf(s)/Unit Total : 4.9613 sf(s)

Material: 6061-T6 0.080" thick

(M6061T6S.080)

Batch: *M100785*

M10178

063 - scrap 4.9613 sf
ml 06 06 12/14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3066

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

ml 06 06 12/14

(50)

H.M 06-06-15

49

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 06 12/14

(50)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06.06.15



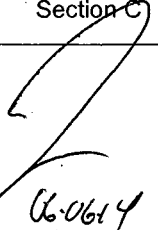

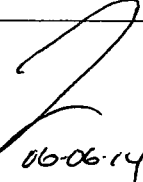

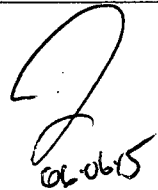
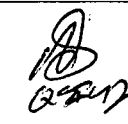

49

5.0 QC8 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-14	2	Mat'l is .060 thick. Dwg requires .080 6061T6 or 5052.		Scrap destroyed & replace with .080	 06-06-14	 06-06-14		 06-06-14
06-06-15	2	1 part scrap. Mat'l under tol. Around 1 hole due to water jet blow out.		Scrap: destroyed	MF. 06-06-15	 06-06-15		 06-06-15

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27526

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06-06-15 (49)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

J.E. 06-06-15 (49)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA18

s/b some 2 hours?

J.E. 06-06-15 (49)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 06/06/16 (49)

Job Completion



W 06-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

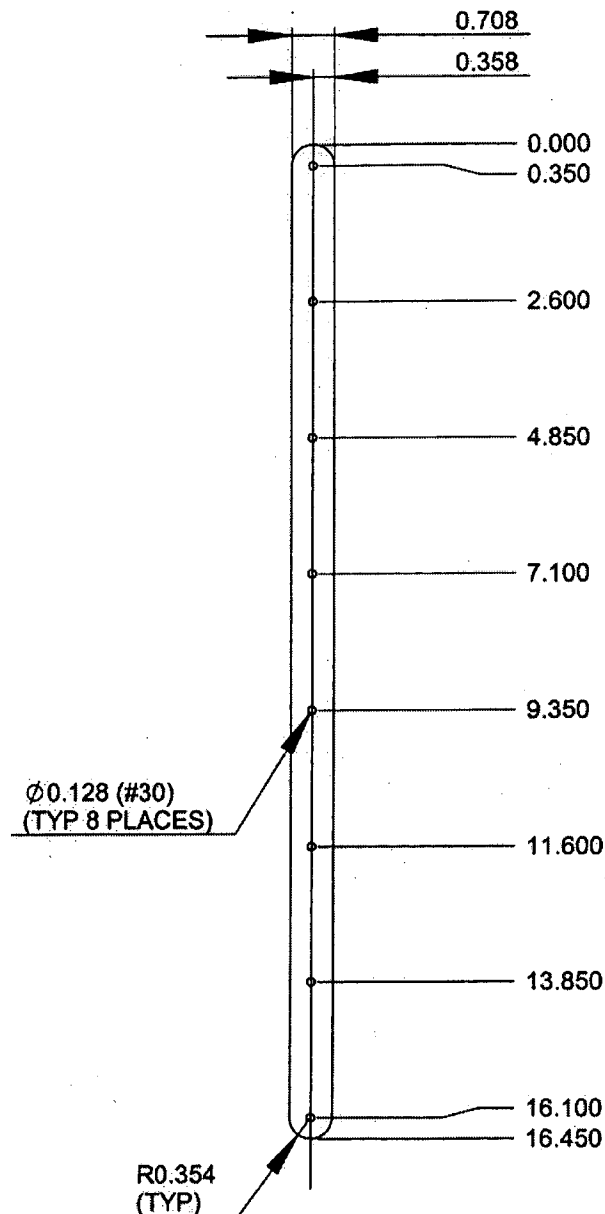
QA: N/C Closed: _____ Date: _____



COPY ISSUE

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	REV. A SHEET 1 OF 1
DATE 02.09.11	TITLE SPACER		SCALE 1:3
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3066-1 SPACER

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WORK ORDER
NO. 27526

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